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RBE350A94-3700-A
Job Sheet R203653



Part No: RBE350A94-3700-A

Job Qty: 6 pcs

Part Name: Swashplate Immobilizing Tools Long Brace & Parts



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/22/19

Job Tracking No: rusted - needs rework

Due Date: 1/27/20

Created By: Linda Lacelle

Type: Rework

Description:

Note: DWG RBE350A94-3700-A Rev 7 IPP Rev A 18.01.16 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
111	Rework - 1 - Startup	6 pcs	1/27/20	1/27/20	0.00	1.20	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
112	Rework - 2 - B4B	6 pcs	1/27/20	1/27/20	0.00	1.00	Handfinish - 7 - 1 - B4B		GD 19-61-09. BB
							Handfinish - 7 - 2 - B4B		
113	Rework - 3 - B4B	6 pcs	1/27/20	1/27/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
114	Outsource - 7 - Rework	6 pcs	1/27/20	1/27/20			GRO002-VC	5	2019-12-20

115 Rework - 4 - B4B	6 pcs	1/27/20	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
116 Rework - 5 - B4B	6 pcs	1/27/20	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
117 Rework - 6 - B4B	6 pcs	1/27/20	0.00 1.50	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
120 QC 5	6 pcs	1/27/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	

				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS 40
				QC 5 - 61	9-89
				QC 5 - 81	
130 Packaging 3-1 - Stock - B4B 6 pcs	1/27/20	0.00 0.00		Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	DAS 28
				Packaging 3 - 5 - B4B	9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG 6 pcs	1/27/20	0.00 0.00		QC 21 - FG - 21	DAS 21
				QC 21 - FG - 70	JAN 1 0 2020
				QC 21 - SA - 53	JAN 1 0 2020

Part Op 111 - 1-Disassemble. Bag parts to be reworked (black oxide) accordingly for outsource supplier and identify material type
 Descriptions: as per drawing. 2-Identify hardware accordingly for reassembly at sequence 117.

112 - 1-Bead blast, remove rust and black oxide.

113 - (QC5- Inspect part completeness to step on W/O)

114 - Issue P/O; 45382 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM & Stress Proof -Certificate of Conformity is required

115 - (Pac2-Receive & Inspect for Damage & Mat'l Certs.)

116 - (QC6- All purchased or subcontracted products)

117 - 1-Re assemble using previously removed parts at sequence 111.

120 - (QC5- Inspect part completeness to step on W/O)

1/9/2020

[Dart Hawkesbury] Job Sheet - Leroux, Jason

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE350A94-3700-A	Swashplate Immobilizing Tools Long Brace & Parts	6 pcs (1 ea)	111-Rework - 1 - Startup	5187059
3896T31	Ferule 1/16 X 3/8" - Aluminum	6 Ea (1 ea)	117-Rework - 6 - B4B	5199293

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
111-Rework - 1 - Startup	RBE350A94-3700-A	6	10	0
117-Rework - 6 - B4B	3896T31	6	436	0

Part Specifications

Specifications could not be found.

Plex 1/9/20 2:52 PM dart.leroux.jason

JAN 08 2023

3X -1A

REMOVE BEFORE FLIGHT

REMOVE BEFORE FLIGHT

REMOVE BEFORE FLIGHT

RBEA62309



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1A	3	LONG BRACE ASSEMBLY			2
	1		-01		TUBE	DOM		3
	1		-03		CAP	SP		4
	1		-05		FOOT	1018/1020 CR		5
	1	B/O	-07		EXTENDED POINT SET SCREW, DOG POINT	STEEL	M6 X 1 X 30mm (MCMMASTER-CARER #92905A225)	2
	1	B/O	-09		REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	2
	1	B/O	-11		LANTYARD	COATED STEEL	Ø1/16 X 14 (CARR LANE #CL-2-C)	2
	2	B/O	-13		FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMMASTER-CARR #3896T31)	2
	ASSY -1A							

TITLE		AEROSPACE	
SWASHPLATE IMMOBILIZING TOOL LONG BRACE			
DWG NO.		RBE350A94-3700-A	
REV		7	
MATERIAL		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
PART		.XXX ± .005 FRACTIONS ± 1/8	
FINISH		.XX ± .01 ANGLES ± 5°	
SPEC		.X ± .01 SURFACES ± .125	
DRAWN BY:		1. BREAK ALL SHARP EDGES D15 X .45" OR .315"	
CHECKED:		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DPPS APPR:		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR:		LINDSAY	
APPROVED:		GILBERT	
SCALE		1:5	
DATE		8/21/2012	
EUROCOPTER		AS350/355	
SHEET 1 OF 5			